

Ship July 6

Work Order ID 85737

85737

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June-14-12 1:55:53 PM

Item ID: D350-607-547

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Utility-Basket

Start Date: 14/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/14

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-607-3	A								
100		0.00							
100	DOCUMENT CONTROL								
DC		0.00							
Document Control	Memo								
	Photocopy bluefile & type labels per PPPD350-607-547 CHG003								
140	Pick Kit	0.00							
140									
Packaging		0.00							
Packaging	Memo								
150	QC4- 100% Inspect kits for completeness	0.00							
150									
QC		0.00							
Quality Control	Memo								

6521711
h

1X

SP
12-7-9.

8.2.2.11

100

Work Order ID 85737

85737

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June-14-12 1:55:53 PM

Item ID: D350-607-547

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Utility-Basket

Stop ***NS2***

Start Date: 14/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Packaging	0.00							
160									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-607-547								
	Location: _____								
		Rev B							
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

1x 8p 12-7-11

MCJ 12107111
MCJ 1407111

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev F

Picklist Print

June-14-12 1:55:56 PM

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Work Order ID: 85737

85737

Parent Item: D350-607-547

D350-607-547

Parent Item Name: Heli-Utility-Basket

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10-08-19 AS PER REV.A DD VERF BY:EC IPP
REV:B 12.03.06 AS PER ECN12-535 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D350-607-511 *CHUR*
D350-607-511
Quick Release Basket Mounting Installation

Manufactured	No	140	Each	3.0000	1	1							
--------------	----	-----	------	--------	---	---	--	--	--	--	--	--	--

** *85742*

Location	Loc Qty	Loc Code
PK13	3	
85131	1	
85132	1	
85133	1	

D2690-6
D2690-6
Lanyard Assembly

Manufactured	No	140	Each	12.0000	1	1							
--------------	----	-----	------	---------	---	---	--	--	--	--	--	--	--

** *B8575780 C*

Location	Loc Qty	Loc Code
ST014	12	
83360	12	

D3912-041
D3912-041
Eyebolt Receiver Assembly

Manufactured	No	140	Each	0.0000	1	1							
--------------	----	-----	------	--------	---	---	--	--	--	--	--	--	--

** *B85952 R*

D4032-043
D4032-043
Short Basket Assembly, Light Lid (350)

Manufactured	No	140	Each	0.0000	1	1							
--------------	----	-----	------	--------	---	---	--	--	--	--	--	--	--

** *85738*

D4085-3
D4085-3
Placard, Instructions

Manufactured	No	140	Each	6.0000	1	1							
--------------	----	-----	------	--------	---	---	--	--	--	--	--	--	--

** *SP 127-9*

Location	Loc Qty	Loc Code
ST092	6	
83657	6	

IX

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other <input type="checkbox"/> </div> <div> Engineering Quality <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Offset/Setup											
Other											
Process											
Supplier											
Training											
Unauthorized											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	Hardware <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong Drill Holes <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	General <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing	<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material	<input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____

Picklist Print

June-14-12 1:55:56 PM

Page 3

Work Order ID: 85737

Parent Item: D350-607-547

Parent Item Name: Heli-Utility-Basket

85737

D350-607-547

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN4-13A
AN4-13A
Bolt

Purchased

No

140

Each

1,346.000

**



6

Sp

Location

Loc Qty

Loc Code

ST357

1346

120187

19

120422

2

120770

25

121652

1000

122063

300

Loc

AN4C15
AN4C15
BOLT

Purchased

No

140

Each

50.0000

**



1

Sp

Location

Loc Qty

Loc Code

ST358

50

120124

1

121146

49

140

Each

30.0000

**



1/x

1

AN310C4
AN310C4
Nut

Purchased

No

Location

Loc Qty

Loc Code

ST344

30

120360

5

121166

3

121444

22

m122151 Sp.
12-7-9.

Picklist Print

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Work Order ID: 85737

85737

Parent Item: D350-607-547

D350-607-547

Parent Item Name: Heli-Utility-Basket

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS17984-C413

Purchased

No

140

Each

19.0000

MS17984-C413

PIN, QUICK RELEASE

**

SP 122141. C

Location

Loc Qty

Loc Code

ST315

3

114340

1

118612

2

ST333

16

121350

16

MS21042L4

Purchased

No

140

Each

3,157.000

MS21042L4

Nut

**

SP 12-7-9. C

Location

Loc Qty

Loc Code

ST300

3157

119075

116

121011

232

121444

2509

121652

300

MS24665-151

Purchased

No

140

Each

191.0000

MS24665-151

Cotter Pin

**

SP 12-7-9. C

Location

Loc Qty

Loc Code

ST309

191

17566

191

Picklist Print

June-14-12 1:55:56 PM

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Work Order ID: 85737

Parent Item: D350-607-547

Parent Item Name: Heli-Utility-Basket

85737

D350-607-547

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H4L

Purchased

No

140

Each

413.0000

2

2

*NAS1515H4I *

WASHER

**

sp. L

Location

Loc Qty

Loc Code

FG

8

103691

8

ST277

405

118709

12

120390

393

140

Each

636.0000

12

12

**

2x sp. L

NAS1149F0432P

Purchased

No

NAS1149F0432P

Washer

Location

Loc Qty

Loc Code

ST275

636

121350

636

140

Each

828.0000

3

3

**

12x M122151 sp. L 12-7-9

NAS1149C0463R

Purchased

No

NAS1149C0463R

Washer

Location

Loc Qty

Loc Code

FP001

1

115358

1

ST297

827

117735

17

119097

810

3x

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Offset/Setup									
Other									
Process									
Supplier									
Training									
Unauthorized									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	Hardware <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong Drill Holes <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	General <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing	<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material <input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-607-541 (Standard Basket)	80.7 lb 36.6 kg	± 49.1 in ± 1.25 m	± 3962 in-lb ± 45.8 m-kg	135 in 3.43 m	10895 in-lb 125.5 m-kg
D350-607-543 (Lightweight Basket)	65.7 lb 29.8 kg	± 49.1 in ± 1.25 m	± 3226 in-lb ± 37.3 m-kg	135 in 3.43 m	8870 in-lb 102.2 m-kg
D350-607-545 (Standard Basket)	58.7 lb 26.2 kg	± 49.1 in ± 1.25m	± 2882 in-lb ± 32.8 m-kg	135 in 3.43 m	7925 in-lb 89.9 m-kg
D350-607-547 (Lightweight Basket)	47.7 lb 21.6 kg	± 49.1 in ± 1.25 m	± 2342 in-lb ± 27.0 m-kg	135 in 3.43 m	6440 in-lb 74.1 m-kg
D350-607-511 (Quick Release Basket Mounting Kit)	7.2 lb 3.3 kg	± 36.9 in ± 0.94 m	± 266 in-lb ± 3.1 m-kg	135 in 3.43 m	972 in-lb 11.3 m-kg

5.0 PARTS LIST

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET
	X					D350-607-543	HELI-UTILITY-BASKET
		X				D350-607-545	HELI-UTILITY-BASKET
			X			D350-607-547	HELI-UTILITY-BASKET
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
					X	D350-607-501	CONVERSION KIT
1	1	1	1		1	D2690-6	LANYARD
				4	4	D3910-3	X-TUBE LUG
1	1	1	1		1	D3912-041	EYEBOLT RECEIVER ASSY
				8	8	D3984-030	RUBBER EXTRUSION, X-TUBE
1						D4030-041	LONG BASKET ASSY
	1					D4030-043	LONG BASKET ASSY, LIGHTWEIGHT
		1				D4032-041	SHORT BASKET ASSY
			1			D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
1	1	1	1		1	D4085-3	PLACARD-INSTRUCTIONS
1					1	D4086-200	PLACARD, MAX LOAD
	1				1	D4086-215	PLACARD, MAX LOAD
		1			1	D4086-220	PLACARD, MAX LOAD
			1		1	D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
1	1	1	1		1	D4150-041	ATTACHMENT ARM ASSY
1	1	1	1		1	D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
1	1	1	1		1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
6	6	6	6		6	AN4-13A	BOLT
				16	16	AN4-14A	BOLT
1	1	1	1		1	AN4C15	BOLT
1	1	1	1		1	AN310C4	CASTELLATED NUT
1	1	1	1		1	MS17984-C413	QUICK RELEASE PIN
6	6	6	6	16	22	MS21042L4	NUT (OR MS21042-4)
1	1	1	1		1	MS24665-151	COTTER PIN
2	2	2	2		2	NAS1515H4L	WASHER
12	12	12	12	32	44	NAS1149F0432P	WASHER
3	3	3	3		3	NAS1149C0463R	WASHER

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Revision: A

Date: 10.06.28

Work Order ID 85737

June-14-12 1:55:53 PM

Ship July 6

85737

Page 1

Item ID: D350-607-547

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Utility-Basket

Start Date: 14/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/14

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-607-3	A								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPPD350-607-547 CHG003								
140	Pick Kit	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC4- 100% Inspect kits for completeness	0.00							
150									
QC	Memo	0.00							
Quality Control									

CD 12/07/09